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Sub D2  
openings of truncated channels, formed between internal and external shells of stacked, conical insert members, said annular slits feeding said polymer melts from said truncated channels into an inside wall of said central annular channel, and said internal and external shells of said conical insert members having mating interior and exterior conical surfaces which define two counter rotating spiral channels, whose depths taper off in a direction of each smaller diameter opening.

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Sub D4  
5. (Amended) A blown film head comprising a plurality of internal and external shells of stacked insert members which define a central annular channel having inner and outer walls, said shells having mating interior and exterior conical surfaces which define therebetween a plurality of spiral grooves which form truncated conical channels spaced around said central annular channel, said truncated conical channels communicating with said central annular channel to cause polymer melt in said truncated conical channels to empty into said central annular channel to produce multilayered tubes of thermoplastic material.

6. (Amended) The blown film head as claimed in claim 5, wherein said internal truncated conical annular channels and said external truncated conical annular channels slope in opposite directions at approximately the same angle to said central annular channel.

C3 10. (New) An extruder die head, comprising a central annular channel with an annular outlet die slit and an outer limiting wall empty internal annular slits, which feed a polymer melt and which form smaller diameter openings of truncated conical melt feed channels, formed between internal and external shells of stacked, conical insert members, said internal annular slits feeding said polymer melts from said conical melt feed channels into an inside channel, said shells having mating interior and exterior conical surfaces which define therebetween spiral grooves which form said truncated conical melt feed channels.